

Work Order ID 131877

131877

Page 1

Tuesday, April 21, 2015 2:08:17 PM

Item ID: D412-760-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 4/16/15 Start Qty: 2.00 *2*

Required Date: 4/20/15 Req'd Qty: 2.00 *2*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-04-22 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-760	G								
100	Document Control	0.00	DAS 27 9-89						MhJ 12 MAY 12 2015
100	DOCUMENT CONTROL								
DC	Memo	0.00		DAS 6 9-89	2				MAY 14 2015
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPP D412-760-011 CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							DAS 27 9-89
Packaging									2x MAY 12 2015
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							DAS 28 9-89
Quality Control									
				DAS 6 9-89	2				MAY 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Work Order ID 131877

131877

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Tuesday, April 21, 2015 2:08:17 PM

Item ID: D412-760-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cabin Floor Protector
 Start Date: 4/16/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-760-011								
	Location: <u>040</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

2 MAY 20 2015

DAS
6
8-88

MCS MAY 19 2015

MCS MAY 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Page 1

Work Order ID: 131877

131877

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 07.07.05 new issue EC
IPP Rev:B 08-08-20 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3574-1	DAS 6 9-89	Manufactured	No			110	Each	0.0000	1	2		DAS 27 9-89	DAS 28 9-89
D3574-1								B131684	**	2			
Cabin Floor Protector													
D3574-2		Manufactured	No			110	Each	0.0000	1	2		DAS 27 9-89	DAS 28 9-89
D3574-2	DAS 6 9-89							B131460	**	2			
Cabin Floor Protector													
D3575-1	DAS 6 9-89	Manufactured	No			110	Each	0.0000	1	2		DAS 27 9-89	DAS 28 9-89
D3575-1								B131779 B131748	**	2			
Cargo Floor Protector													
D3575-2		Manufactured	No			110	Each	0.0000	1	2		DAS 27 9-89	DAS 28 9-89
D3575-2	DAS 6 9-89							B131870	**	2			
Cargo Floor Protector													
D3580-1		Manufactured	No			110	Each	21.0000	6	12		DAS 27 9-89	DAS 28 9-89
D3580-1									**				
Joggle Bracket													

DAS
6
9-89

Location

Loc Qty

Loc Code

ST050

1

127565

1

ST051A

20

129913

20

MAY 12 2015

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 131877

131877

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

D3628-1

Manufactured No

110

Each

475.0000

14 28

D3628-1

Washer, Cupped

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

83587

10

ST052A

322

123627

322

ST053

143

116783

30

123627

113

D3628-3

Manufactured No

110

Each

227.0000

6 12

D3628-3

Cupped Washer

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST051A

160

96308

160

ST053

67

96308

67

MS24694-S100

Purchased

No

110

Each

60.0000

12

MS24694-S100

Flat Head Screw

**

DAS
27
9-89

MAY 12 2015
DAS
28
9-89

Location

Loc Qty

Loc Code

ST288

60

m131317

60

DAS
6
9-89

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Description Work Order Deviation		Disposition			
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				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Tuesday, April 21, 2015 2:08:16 PM

Work Order ID: 131877

131877

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

MS24694-S54

Purchased

No

110

Each

46.0000

14

28

MS24694-S54

SCREW

DAS
6
9-89

Location

Loc Qty

Loc Code

ST289

46

m130388

6

m131886

40

110

Each

1,719.000

28

56

NAS1149D0363J

Purchased

No

NAS1149D0363.1

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

FP001

2

113288

2

GA

302

m128429

302

ST269

846

m126319

9

m131618

837

110

Each

5,164.000

12

24

NAS1149D0463J

Purchased

No

NAS1149D0463.1

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

5123

M129682

86

M130799

403

M132035

4634

DAS
27
9-89
MAY 27 2015
DAS
28
9-89

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
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OTHER :																					

REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D412-760-011	CABIN FLOOR PROTECTOR KIT
	X				D412-760-013	CABIN FLOOR PROTECTOR KIT
		X			D412-760-015	CABIN FLOOR PROTECTOR KIT
			X		D412-760-017	CABIN FLOOR PROTECTOR KIT
				X	D412-760-019	CABIN FLOOR PROTECTOR KIT
15					D3574-1	CABIN FLOOR PROTECTOR
4					D3574-2	CABIN FLOOR PROTECTOR
1					D3574-3	CABIN FLOOR PROTECTOR
1					D3574-4	CABIN FLOOR PROTECTOR
		1			D3574-5	CABIN FLOOR PROTECTOR
		1			D3574-6	CABIN FLOOR PROTECTOR
11					D3575-1	CABIN FLOOR PROTECTOR
1					D3575-2	CABIN FLOOR PROTECTOR
1					D3575-3	CABIN FLOOR PROTECTOR
1					D3575-4	CABIN FLOOR PROTECTOR
		1			D3575-5	CABIN FLOOR PROTECTOR
		1			D3575-6	CABIN FLOOR PROTECTOR
6	4	6	6	6	D3580-1	JOGGLE BRACKET
			1		D3788-1	CABIN FLOOR PROTECTOR
			1		D3788-2	CABIN FLOOR PROTECTOR
			1		D3788-3	CABIN FLOOR PROTECTOR
			1		D3788-4	CABIN FLOOR PROTECTOR
14	40	14	14	10	D3628-1	CUPPED WASHER
6	8	6	6		D3628-3	CUPPED WASHER
				1	D4122-1	FLOOR PROTECTOR, FORWARD
				1	D4122-3	FLOOR PROTECTOR, AFT
28		28	28		NAS1149D0363J	WASHER (AN960JD10)
12		12	12		NAS1449D0463J	WASHER (AN960JD416)
14		14	14		MS24694S54	SCREW
6		6	6		MS24694S100	SCREW